

Date: Thursday, 18/09/2008 11:12:46 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WELDMENT TOP PANEL
Job Number	: 42096		
Estimate Number	: 13030		
P.O. Number	:	Part Number	: D36505
This Issue	: 18/09/2008 S.O. No. :	Drawing Number	: D3650 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 39934	Material	:
Written By	:	Due Date	: 25/09/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>JUL 08.9.18</u>		
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC		
	: Est Rev:B ECN 1113P 08-01-22 DD		
	: Est Rev:C ecn1162 08-04-02 DD verified by: EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.8537 sf(s)/Unit Total: 4.2683 sf(s)  
 304/316 SS sheet 26 ga (0.018" thick)  
 Batch: 108415 8-9-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3650  
 Dwg Rev: B 18-9-22  
 Prog Rev: B

2-Deburr if necessary 18-9-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE  
 Form as per Dwg D3650

SD 08/09/22 (S)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 18/09/2008 11:12:46 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 42096

Part Number: D36505

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/09/24 (45)

7.0

D36507

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

SEAL

batch

B 42148

50 08/09/24

(5)

8.0

D36509

Angle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ANGLE

batch

42097

h

9.0

AN960C4

WASHER



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

WASHER

batch

M106431

h

10.0

NAS9307M403

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

RIVET

batch

M105940 48P

C R 3523 4-03

15P M106303

h

11.0

MS20427M33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet

batch

M109371

h

12.0

MS210603K

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut Plate

batch

M1068406

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 18/09/2008 11:12:46 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 42096

Part Number: D36505

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 MS210623K Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nut Plate

batch

M10593874

M10866934

LC 8/24 (5)

14.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



PF (5)

Comment: Assemble as per dwg D3650

FF 08-09-25

15.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/10/01 (48)

16.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location

CA

SS 08/10/02

17.0 QC21 FINAL INSPECTION/W/O RELEASE



08/10/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

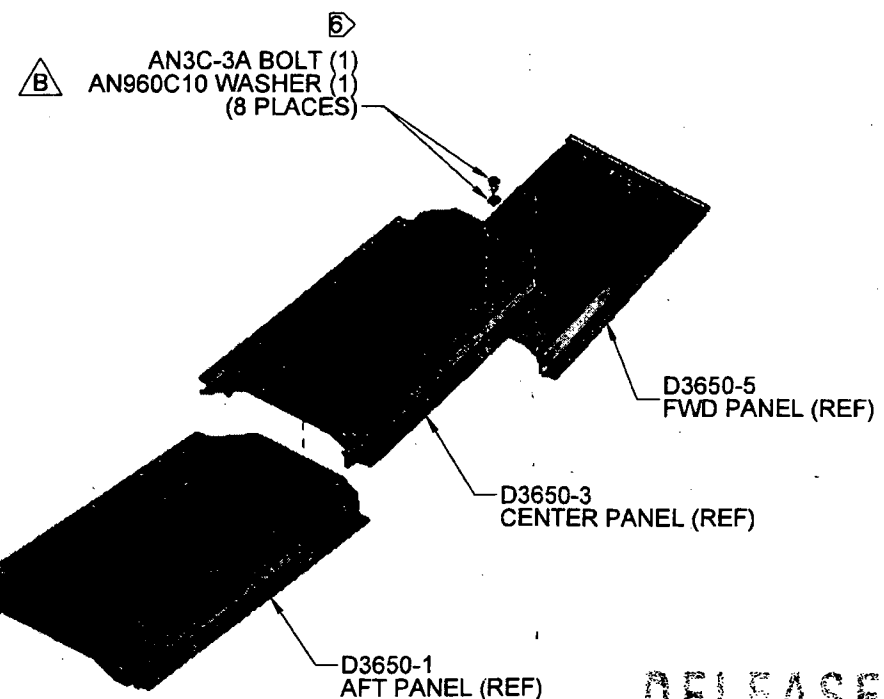
Part No: D3650-5 PAR #: N/A Fault Category: Prod / FAB ASS' mod & SMD NCR: Yes No DQA: D Date: 08/10/03  
D3650-041 / D3648-041 D305-765-011  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: D Date: 08/10/03

NCR: <u>42096</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/09/03</u>	<u>#140</u>	<u>D3650-S was installed on wrong side.</u> <u>RC employee and QC missed lead Dwg.</u>	<u>[Signature]</u>	<u>Drill out rivets and</u> <u>Reinstall on correct side.</u> <u>(TOP)</u> <u># 1459307M-4-03</u>	<u>FF</u> <u>08/10/01</u>	<u>[Signature]</u> <u>08/10/01</u>	<u>[Signature]</u>	<u>S</u> <u>08/09/03</u>
<u>08/09/03</u>	<u>0.14</u>	<u>Some grit when</u> <u>install pull little</u> <u>more inside new</u> <u>batch of rivet</u>		<u>B# MLC6303</u>	<u>FF</u> <u>08/10/01</u>			

NOTE: Date & initial all entries



8 7 6 5 4 3 2 1

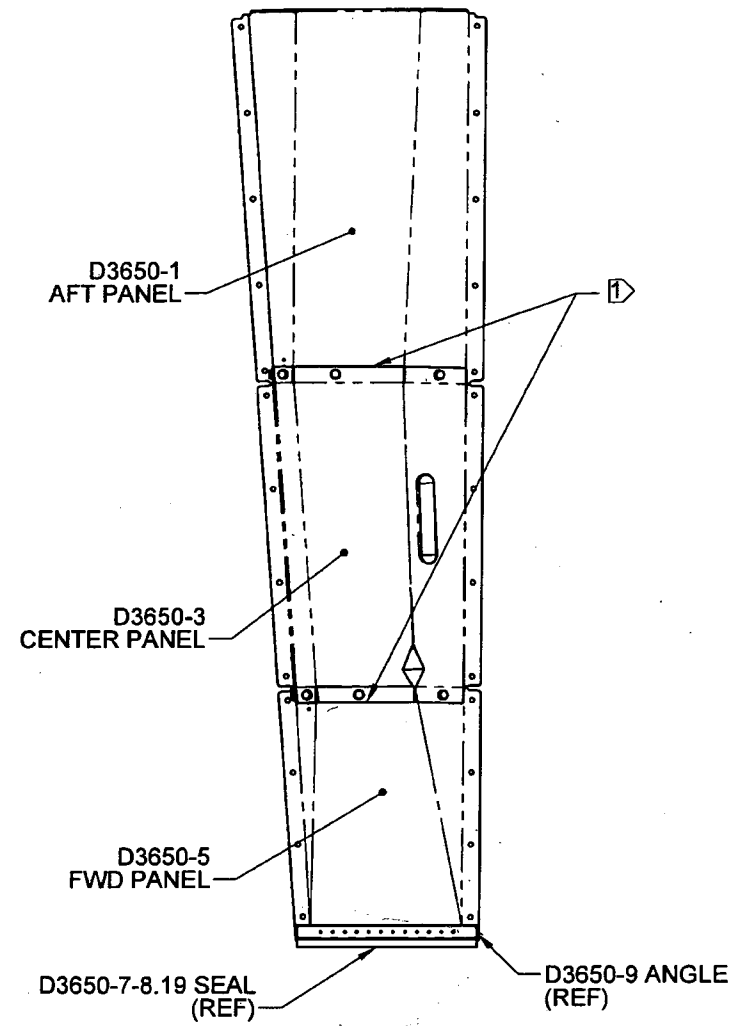


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08-03-17

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

B



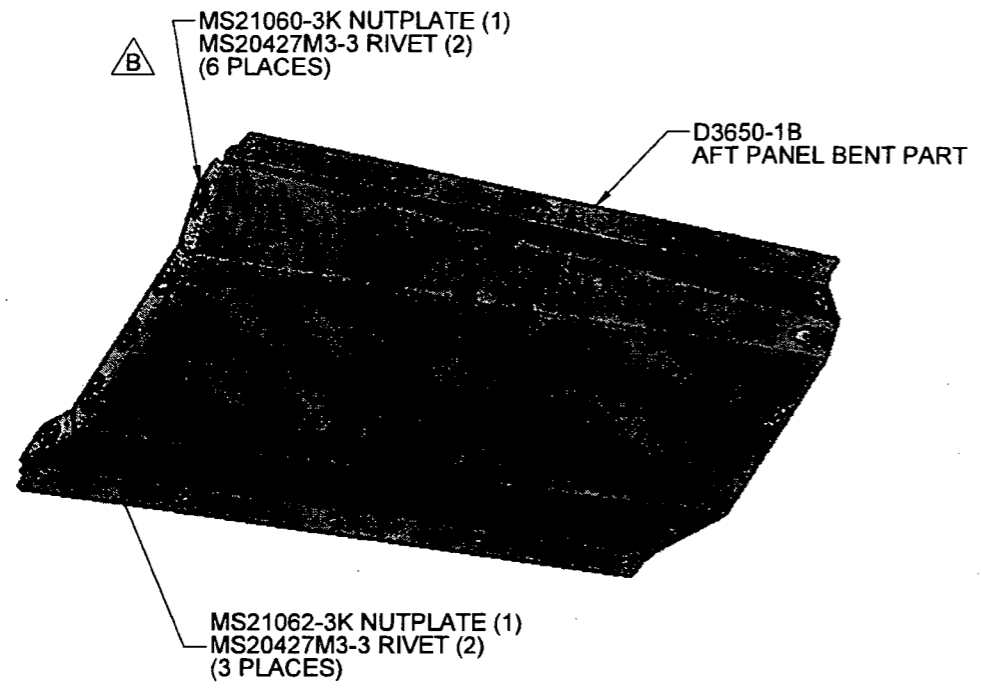
D3650-041 TUNNEL TOP PANEL ASSEMBLY

- NOTES:
- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 5) IDENTIFICATION: NONE
  - 6) TORQUE FASTENERS 15 TO 25 in-lb
  - 7) WEIGHT: 3.3 lbs

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F		RF	08.01.07
	A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE	
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF	DRAWING NO.	REV. B	
CHECKED	LE	D3650	SHEET 1 OF 9	
MFG. APPR.	MA	TITLE	TOP PANEL ASSEMBLY	
APPROVED	MA	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DE APPR.	MA	SCALE 1:8 RETURN TO ENGINEERING		
DATE	08.01.07	UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 42016		

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



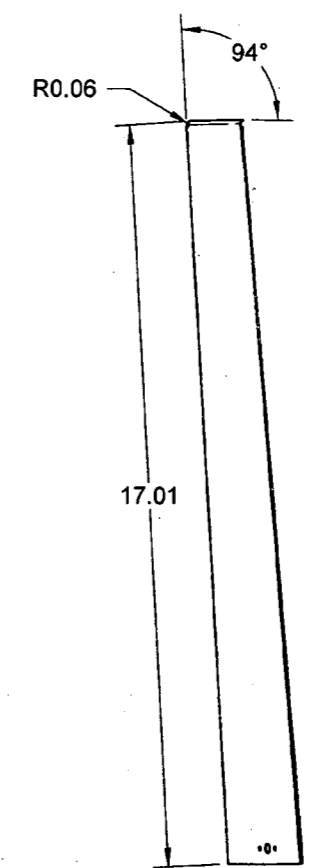
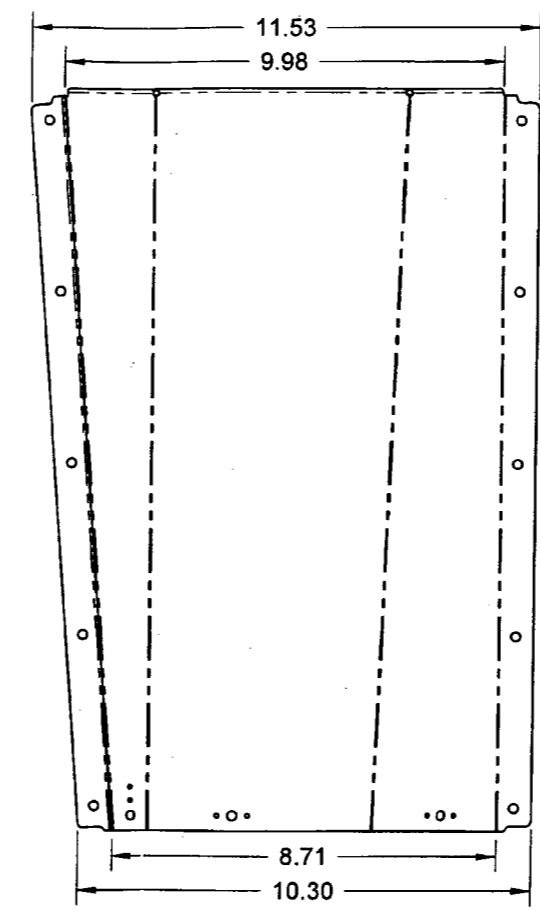
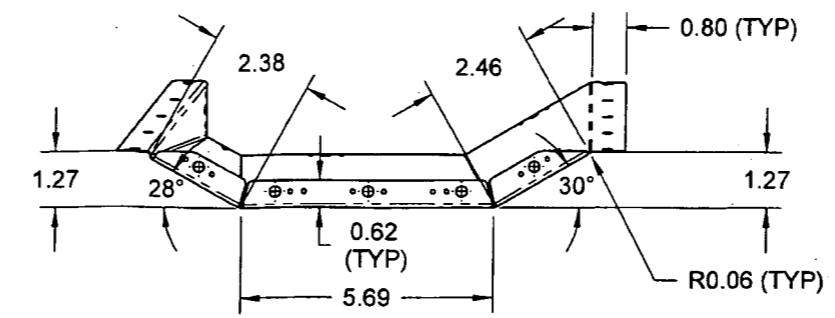
**D3650-1 AFT PANEL**

**PART LIST**

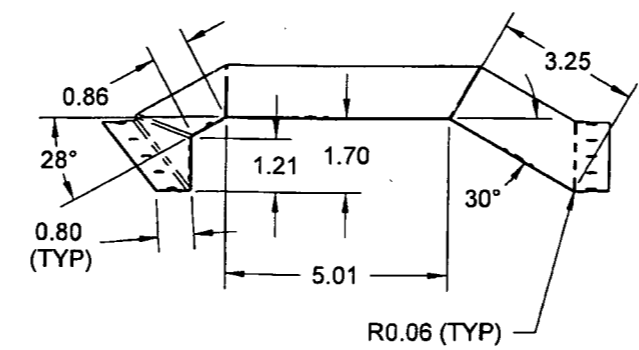
QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

**B**

- NOTES:  
1) FINISH: NONE  
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) UNITS: INCHES UNLESS OTHERWISE NOTED  
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
5) IDENTIFICATION: NONE  
6) WEIGHT: 1.3 lbs



**D3650-1B AFT PANEL BENT PART**  
(MAKE FROM D3650-1F FLAT PATTERN)

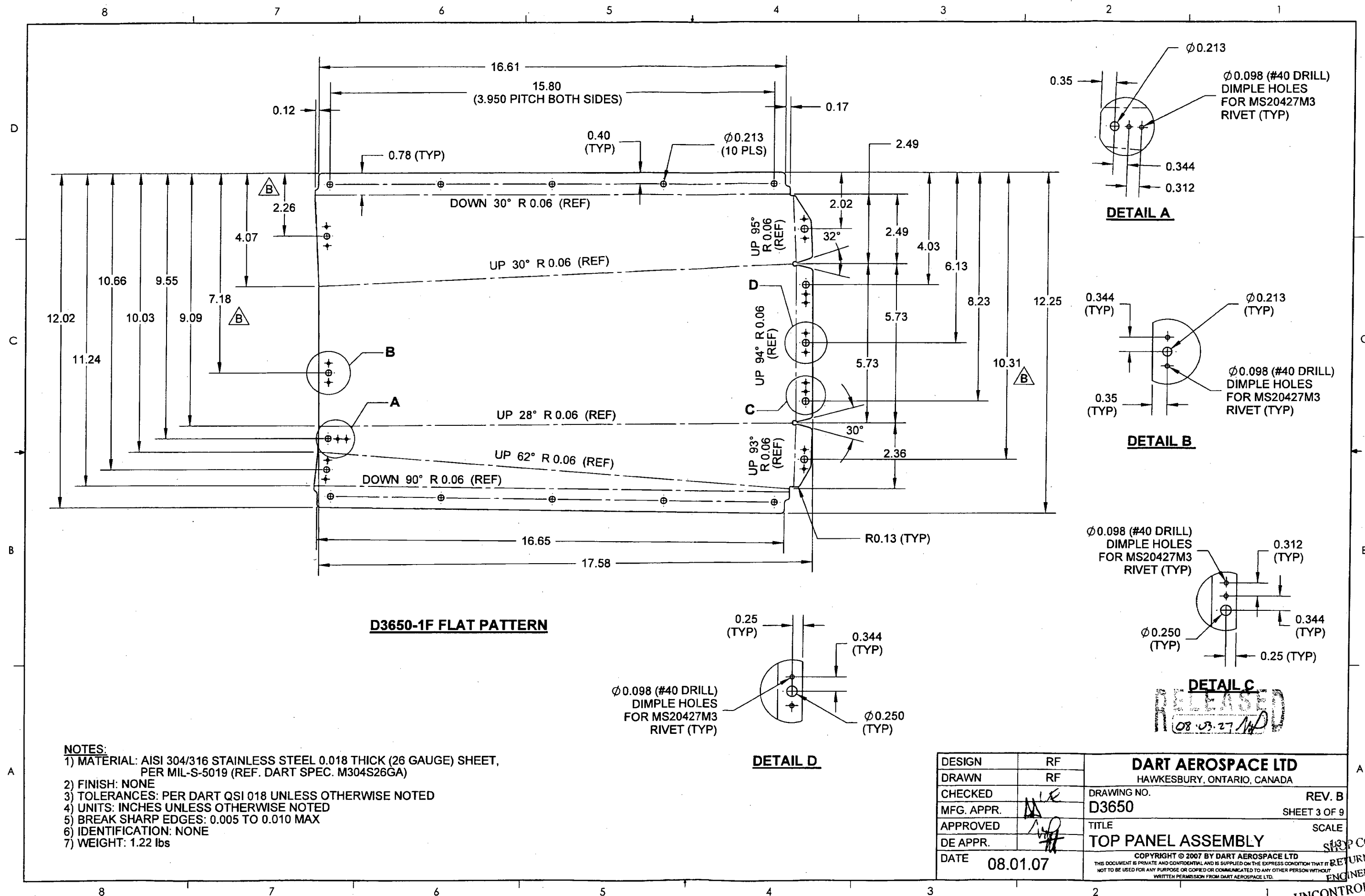


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08-03-27

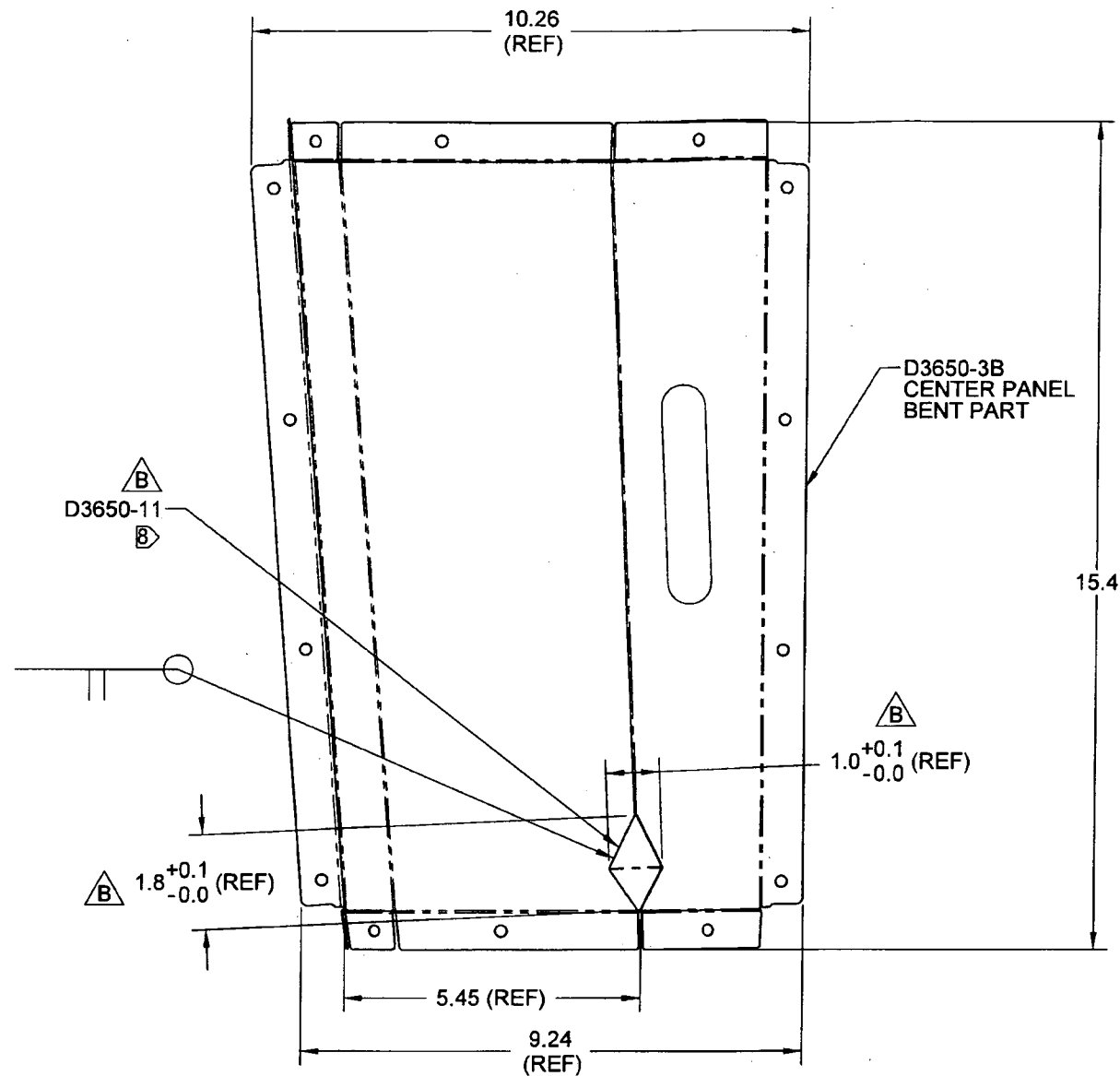
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	1:4 ENGINEERING
DE APPR.		TOP PANEL ASSEMBLY	UNCONTROLLED COPY
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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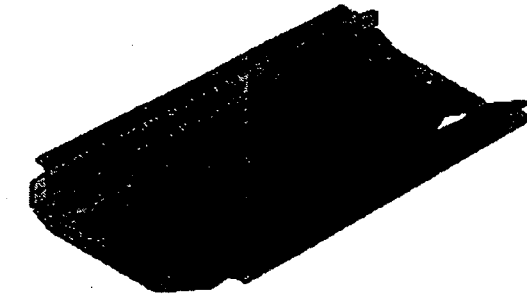
8 7 6 5 4 3 2 1



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 NO. 42076



**D3650-3 CENTER PANEL**



**PART LIST**

QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

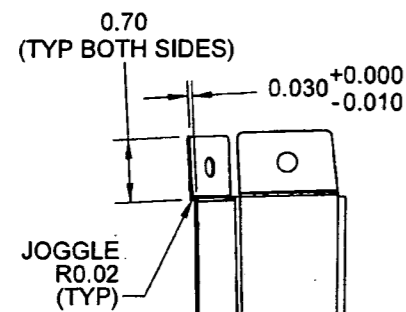
**NOTES:**

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED

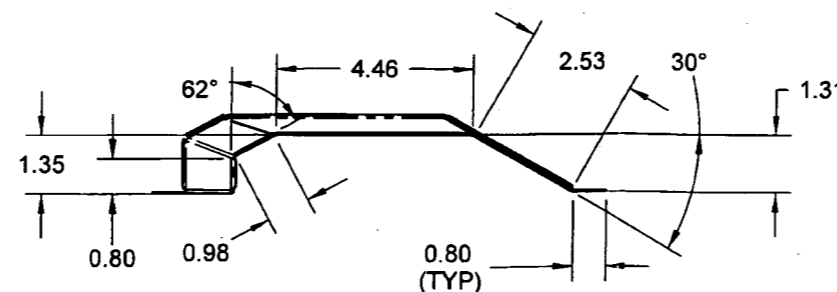
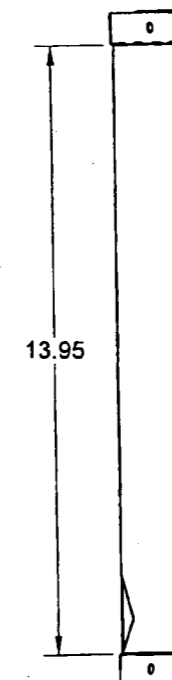
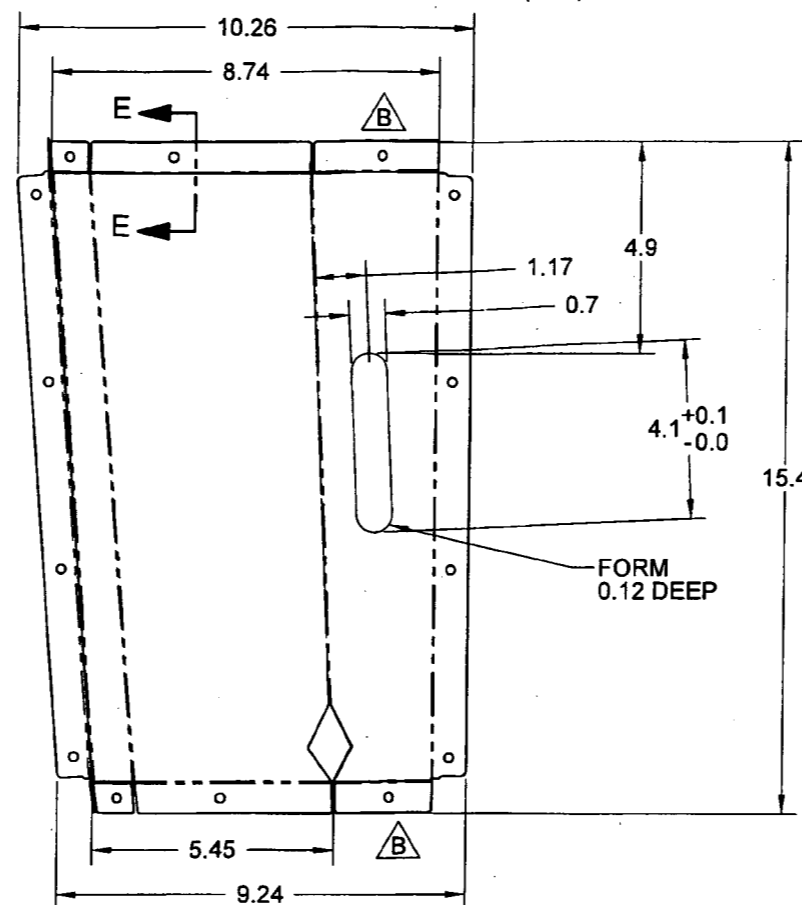
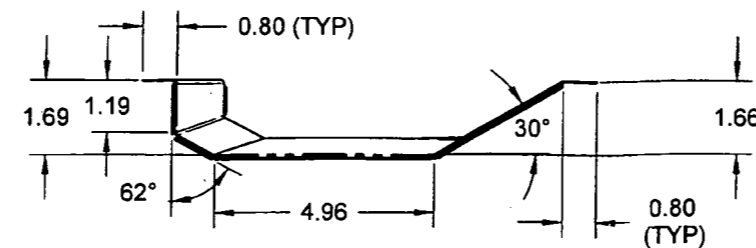
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08-03-27

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	KE	DRAWING NO. D3650
MFG. APPR.		REV. B
APPROVED		SHEET 4 OF 9
DE APPR.		TITLE TOP PANEL ASSEMBLY
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NO. 42096



# **SECTION E-E**



## **NOTES:**

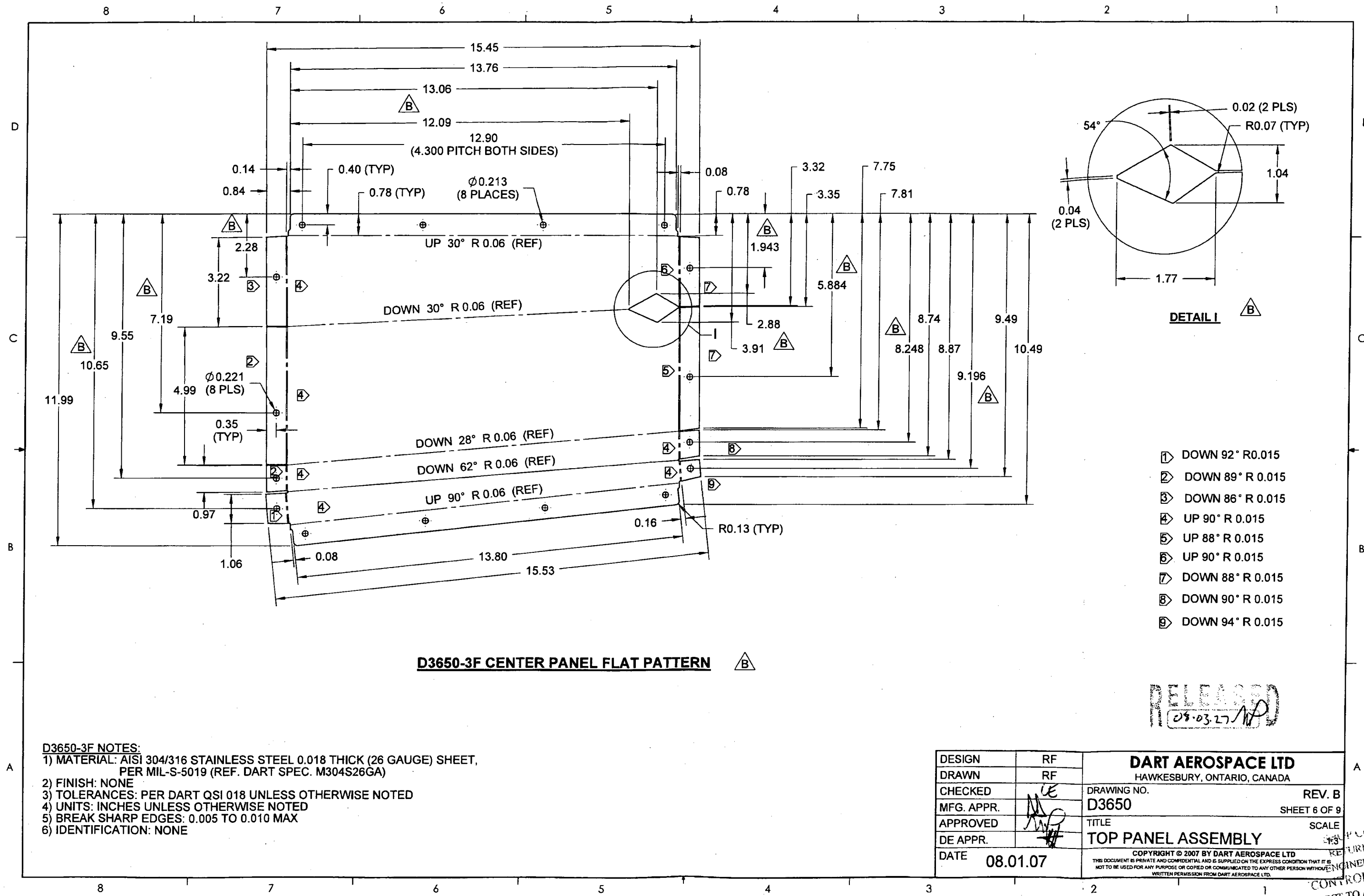
- 1) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

## **D3650-3B CENTER PANEL BENT PART** (MAKE FROM D3650-3F FLAT PATTERN)

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. <b>D3650</b>	REV. B
MFG. APPR.		SHEET 5 OF 9	
APPROVED		TITLE <b>TOP PANEL ASSEMBLY</b>	SCALE 1:4
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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WORK ORDER  
NO. 42096



- 1) DOWN 92° R 0.015
- 2) DOWN 89° R 0.015
- 3) DOWN 86° R 0.015
- 4) UP 90° R 0.015
- 5) UP 88° R 0.015
- 6) UP 90° R 0.015
- 7) DOWN 88° R 0.015
- 8) DOWN 90° R 0.015
- 9) DOWN 94° R 0.015

**D3650-3F CENTER PANEL FLAT PATTERN**

**D3650-3F NOTES:**

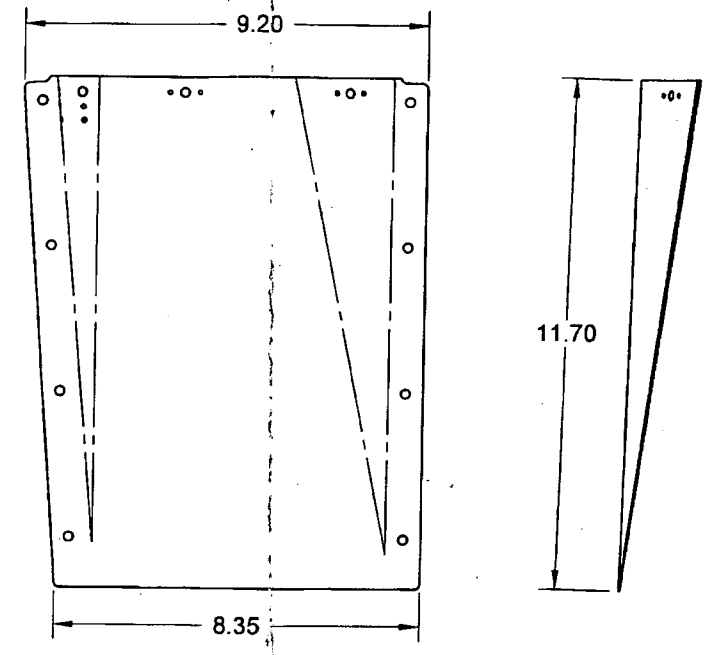
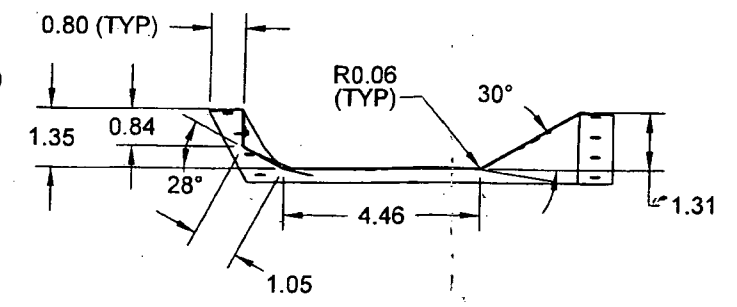
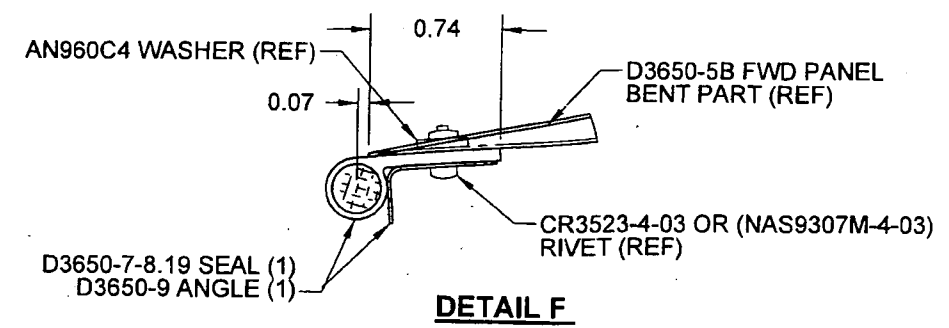
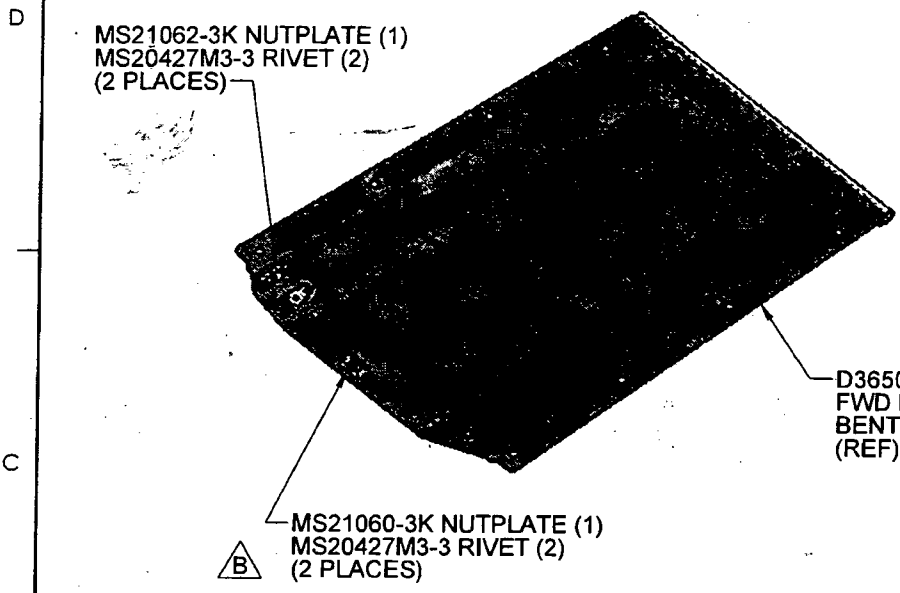
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.	AWP	D3650	SHEET 6 OF 9
APPROVED	AWP	TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:1
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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 WITHOUT NOTICE  
 WORK ORDER NO. 42096

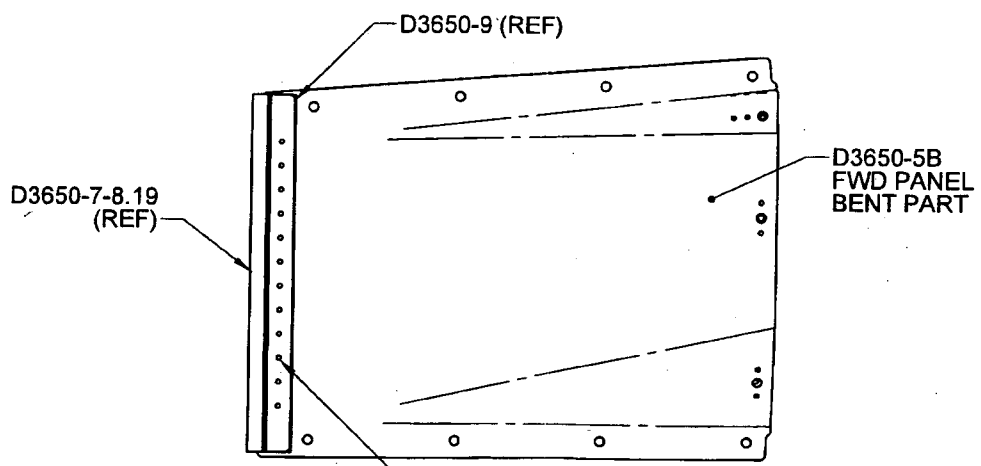


8 7 6 5 4 3 2 1



PART LIST

QTY -5	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE



CENTRE D3650-7/-9 ON D3650-5B & TRANSFER Ø0.129 (#30 DRILL) HOLES FROM D3650-9 TO D3650-7 & D3650-5B AS SHOWN  
INSTALL  
CR3523-4-03 OR NAS9307M-4-03 RIVET (1)  
AN960C4 WASHER (1)  
(12 PLACES)

D3650-5 FWD PANEL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

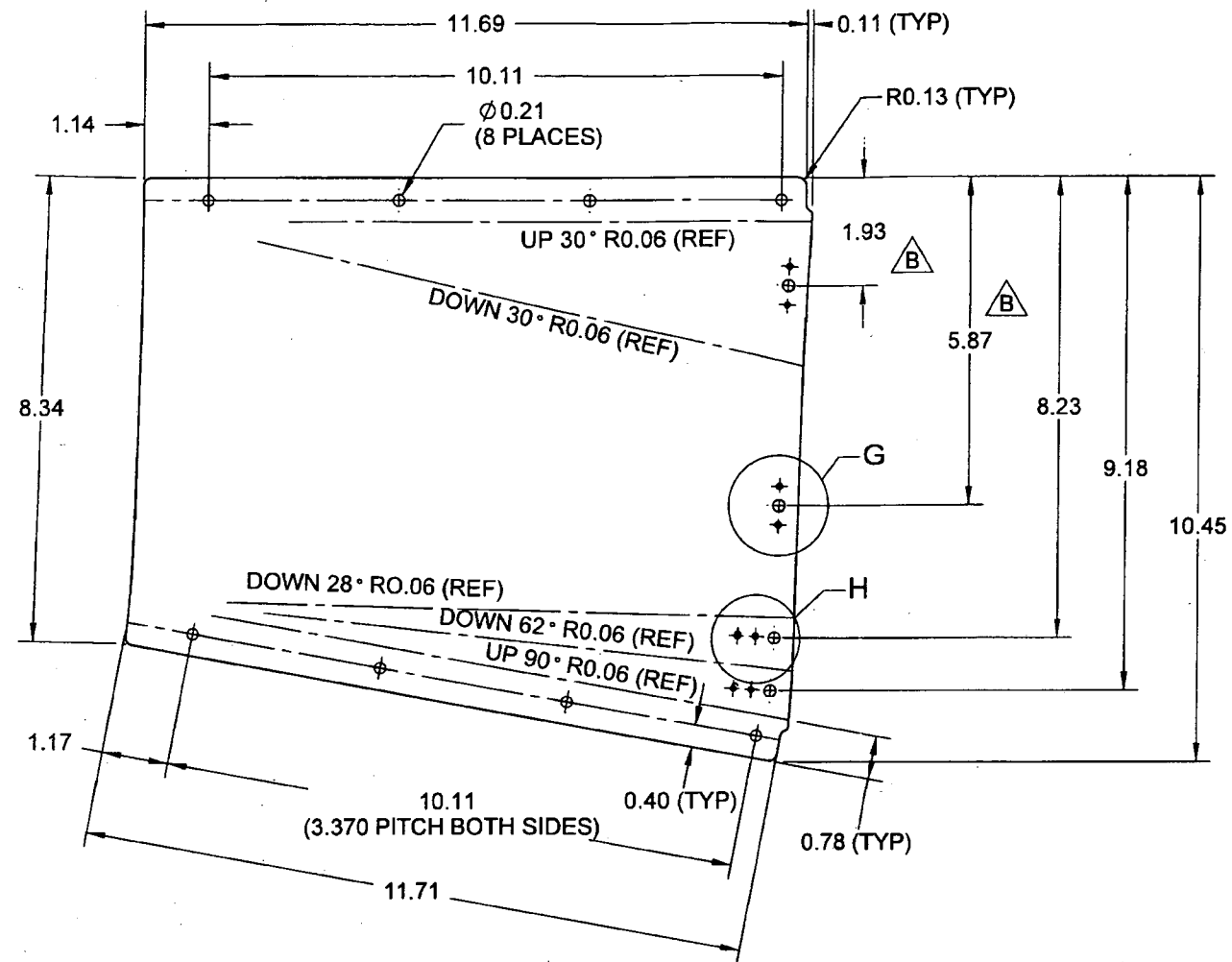
D3650-5B FWD PANEL BENT PART  
(MAKE FROM D3650-5F FLAT PATTERN)

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08 03 27 / WP

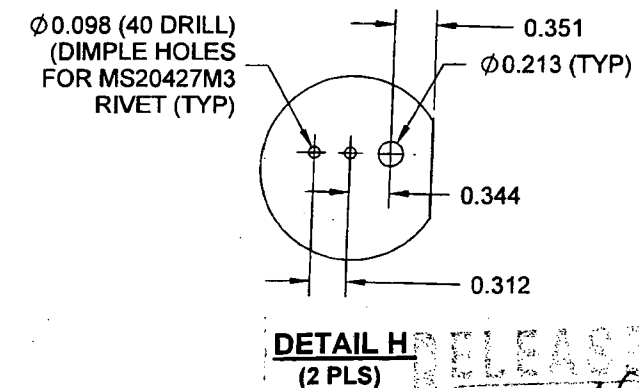
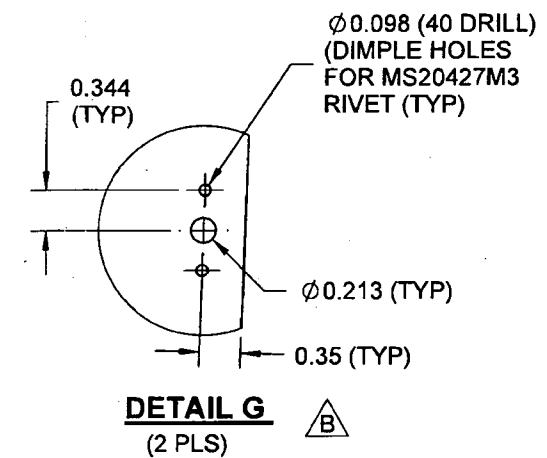
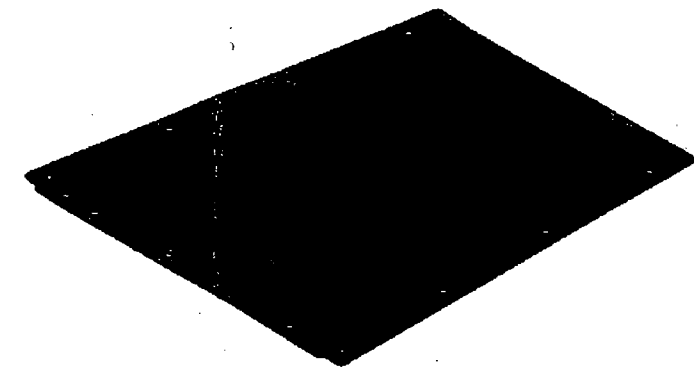
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	RF	DRAWING NO. D3650
MFG. APPR.	RF	REV. B SHEET 7 OF 9
APPROVED	RF	TITLE TOP PANEL ASSEMBLY
DE APPR.	RF	SCALE 1:4
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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WORK ORDER  
NO. 42096

8 7 6 5 4 3 2 1



**D3650-5F FLAT PATTERN**

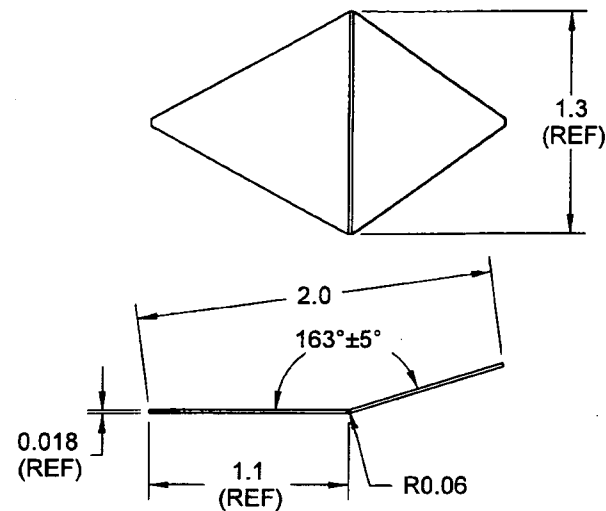


**NOTES:**

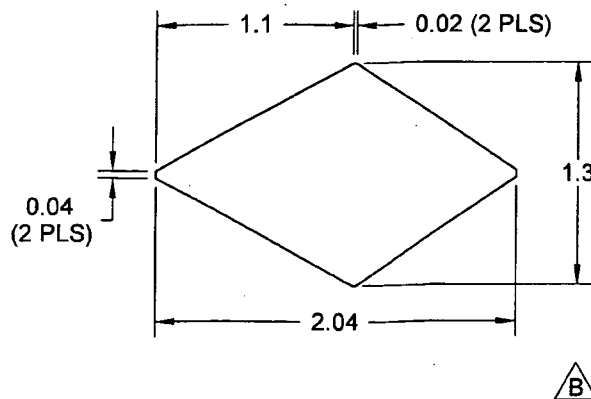
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	ENGINEERING
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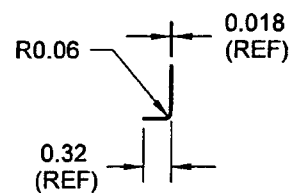
WITHOUT NOTICE  
WORK ORDER  
NO. 420910



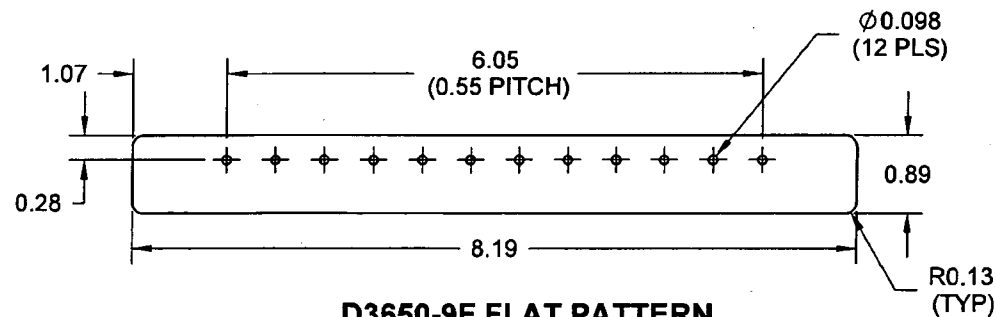
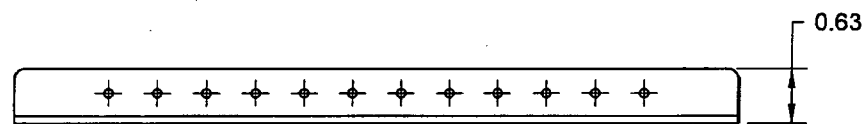
**D3650-11 FILLER PLATE**  
(MAKE FROM D3650-11F FLAT PATTERN)  
(SCALE 1:1)



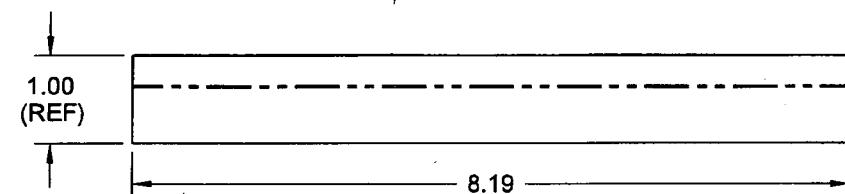
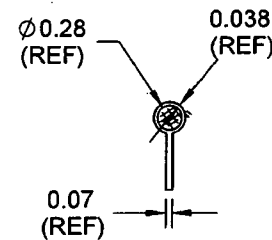
**D3650-11F FLAT PATTERN**  
(SCALE 1:1)



**D3650-9 ANGLE**  
(MAKE FROM D3650-9F FLAT PATTERN)



**D3650-9F FLAT PATTERN**



**D3650-7-8.19 SEAL**

**D3650-7-8.19 NOTES:**

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)  
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX  
WHERE X.XX = LENGTH IN INCHES  
EG. 12.50" LONG = D3650-7-12.50

**D3650-9 & D3650-11 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,  
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb  
D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	<b>DART AEROSPACE LTD</b>		A
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	KE	DRAWING NO.	REV. B	SHOW COPY SCALE RETURN TO 12 ENGINEERING CONTROLLED COPY FOR AMENDMENT
MFG. APPR.	MA	D3650	SHEET 9 OF 9	
APPROVED	MA	TITLE		
DE APPR.	MA	TOP PANEL ASSEMBLY		
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